

Process/Product Audit Checklist

Cust #: 1795 Customer: BSH GRP/Size/GRD/Width: GVC.0356 DD30CD 26.825

PWC: SSL W/O#: 71977 Date: 11-15-18 Part #(s): 9000913648 Auditor: B.Clem

Gauge Range: .0356-.0387 Actual Gauge: .036 Width Range: 26.794-26.856 Width Actual: 26.842/26.844

Length Range: N/A Length Actual: N/A Other: wt. 2945 lbs Other Actual: 2855 lbs.

Other: N/A Other Actual: N/A Other: N/A Other Actual: N/A

Item	YES	NO	N/A	Comments/Action Taken (Required for NO)
Process Inspection Sheets filled out according to <u>frequency</u> and <u>sampling</u> required?	☒	☐	☐	<u>Tail Gauge noted on FOPIS but was not done. Farron</u>
Correct raw material type and size?	☒	☐	☐	Tag(s) to use: <u>528566</u> Tag(s) used: <u>528566</u>
Setup performed according to W/O?	☒	☐	☐	
Product is acceptable according to customer-specific requirements? [Fab: Is the Part Print Present & the correct Revision? Are required measurements documented?]	☒	☐	☐	[Fab: Print Rev: _____, W/O Rev: _____, Part Spec Rev: _____] (Leave blank if non-Fab audit)
Packaging is acceptable according to customer-specific requirements?	☒	☐	☐	
Visual Inspection performed and product meets requirements?	☒	☐	☐	
Out of spec noted, with actions taken?	☐	☐	☒	
Non-conforming material put into reject warehouse and physically put into non-conforming area?	☐	☐	☒	
Required gages available & functional?	☒	☐	☐	
All Gages Calibrated (List in Comments)	☒	☐	☐	<u>0-240" Caliper 8-29-18 8-29-19</u> <u>0-524" Caliper 1-15-18 1-15-19</u> Gages Observed (list last calibration and when due) <u>13-01 25' Tape 8-16-18 8-16-19</u> <u>11-03 12' Tape 6-29-18 6-29-19</u> <u>m-55 1" mic 11-30-17 11-30-18</u>
Housekeeping: Machine/Floor clean? Loose tags & paperwork cleaned up?	☒	☐	☐	
Required PPE being worn?	☒	☐	☐	
Forms are the latest revision per Quality Intranet?	☒	☐	☐	List Forms (Observed Rev vs Intranet Rev) <u>FOP 015 2-16-01 1</u>
Hardcopy Controlled Documents are listed on Quality Intranet by location?	☒	☐	☐	List Documents and their Location: <u>5MT-SL-001</u> <u>Jm-OP-001</u>

AGT400 Coil Summary Report

Jemison Metals -- 60 Inch Pro-Eco Slitter

Work Order: 71977 Coil Number: 528566

Customer Name: BSH Heat Number: NUB1811809 Vendor: NUB

Product: G30 Galvanized Nov-15-18 10:08 to 10:34 (clock 26.1 min/ run 17.8 min) Shift: 1

Average Thickness and Tolerance Data

Target 36.5 mil Average^ 36.9 mil Average - Target 0.4200 mil (1.15%)
Standard Deviation^ 0.1900 mil (0.52%)

Length 1429 ft Above High Limit 38.0 mil 0 ft (0.0%)
Width 54.150 in In Tolerance 1429 ft (100.0%)
Weight 9734 lbs Below Low Limit 35.0 mil 0 ft (0.0%)

Max Thickness 37.6 mil at 0 ft Min Thickness 36.3 mil at 897 ft
Head Scrap 0 ft Tail Scrap 0 ft

Statistical Process Control Data

Upper Control Limit 37.5 mil Upper Tolerance Limit 38.0 mil
X Double Bar 36.9 mil R Bar 0.6 mil
Lower Control Limit 36.4 mil Lower Tolerance Limit 35.0 mil

CR 38.0% (Capability Ratio %, 100/CP)

CP 2.632 (Process Capability, HiLim-LoLim/6*Sigma)

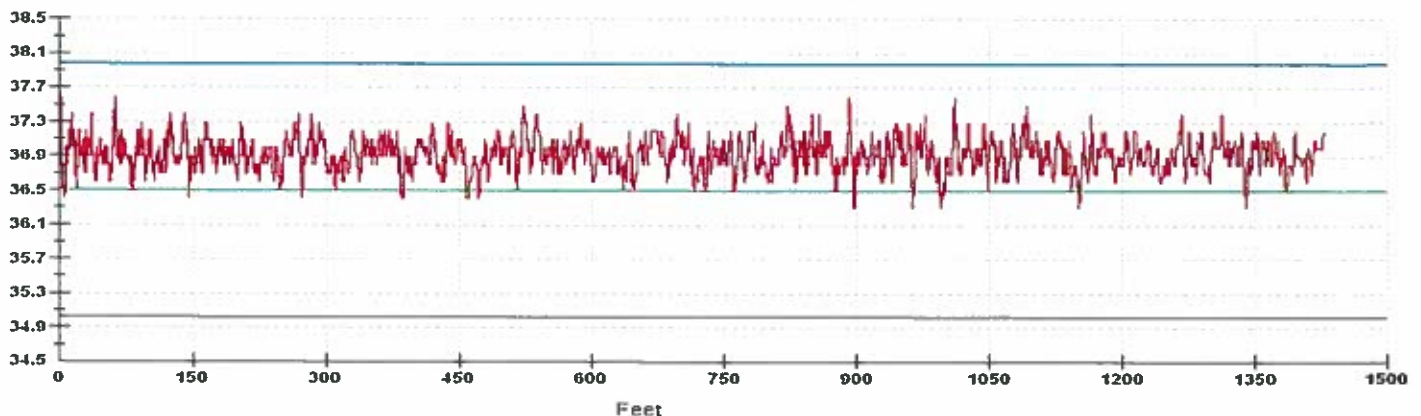
CPK 1.895 (Capability vs Limits) TMW Ratio 0.948 (Low Limit/Avg)

Thickness Distribution Relative to the Target

```
+++ 0.0%
+ 5.0 0.0%
+ 4.5 0.0%
+ 4.0 0.0%
+ 3.5 0.0%
+ 3.0 0.0%
+ 2.5 0.0%
+ 2.0 0.0%
+ 1.5 0.0%
+ 1.0 0.4% *
+ 0.5 43.8% *****>
+ 0.0 54.8% *****>
-0.5 1.0% **
-1.0 0.0%
-1.5 0.0%
-2.0 0.0%
-2.5 0.0%
-3.0 0.0%
-3.5 0.0%
-4.0 0.0%
-4.5 0.0%
-5.0 0.0%
--- 0.0%
```

100.0% is within ± 1.0000 mil of the target 100.0% is within ± 2.5000 mil of the target
100.0% is within ± 5.0000 mil of the target 100.0% is within ± 10.0000 mil of the target

Thickness vs Length (Coil Number 528566)





Manual Inspection Report

EOA023 Revision Codes

JID0P005

JID0P006

JID0P007

JID0P049

Date:

11/15/2018

Job # SMT- 71977

Location: Sumter

Gauge Spec 0.03500

Page # 1

Operator: FMI

Limits 0.03500

Machinist: Target

Slitter 0.03650

CQ 0.06525

HS 0.00700

10h38

0.06875

Horizontal Clearance

Set	Up	Actual	Set	Up	Actual	Set	Up	Actual	Set	Up	Actual	Set	Up	Actual	Set	Up	Actual
1	26.845	26.842	6			11			16			21					
2	26.845	26.844	7			12			17			22					
3			8			13			18			23					
4			9			14			19			24					
5			10			15			20			25					

Set Up Comments:

Check was not done.

	Col #	Open	Rb	Head	1/4	Center	3/4	Tail	Camber	Linear Ft	Burr Hgt	Good PC	Bad PC	Comment
1	528566			E 0.03500	0.03700	0.03700	0.03700	0.03700						
		C 0.03600	0.03600	0.03600	0.03600	0.03600	0.03600							
		E 0.03600	0.03600	0.03600	0.03600	0.03600	0.03600							
		E												
2				C										
	E													
	E													
	E													
3				E										
	C				#									
	E													
	E													
4				E										
	C													
	E													
	E													
5				E										
	C													
	E													
	E													
Start Time	12:00 AM	Stop Time		Start Time		Stop Time		Total Time	0:00	Total Run Time	#####	Cal/Rev Cost	\$550.00 #N/UM	Comment